

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002279**Date Inspected:** 12-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration weld joints # SEG 019A-003, SEG13A-003, SEG014-001 and BP-003-01-001. The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents, however the QA inspector found a no relevant rejectable Class A indication from the weld reinforcement on the SEG 019-001. See UT report TL\_6027 generated on this date.

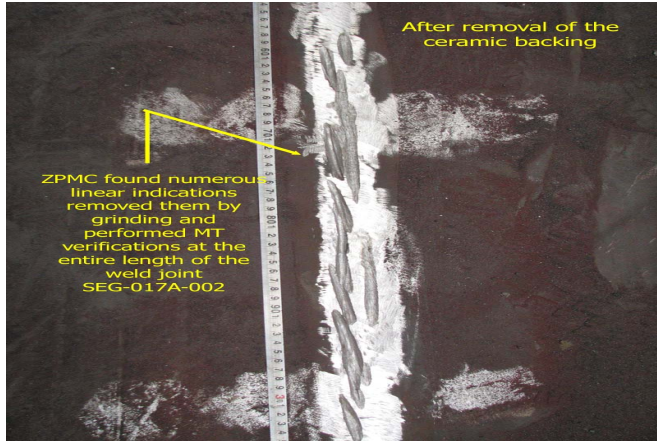
The QA observed ZPMC performing magnetic particle testing (MT) to the weld joint SEG 017A-002 at the time when ZPMC had already completed their testing. The QA inspector asked ZPMC QC representative Mr. Shen Xu Jun what were ZPMC's findings on the backing area of this weld joint and if ZPMC informed Caltrans about the NDT testing performed on this joint. Mr. Shen Xu Jun informed to the QA inspector that ZPMC found lack of fusion in numerous locations that were excavated with the grinder and ZPMC performed MT subsequently until the indications were removed. In addition, Mr. Shen Xu Jun said that ZPMC did not inform Caltrans about the MT performed in this part because it was in process repair. The QA inspector said that ZPMC was required to notify Caltrans on the NDT performed by ZPMC; and the QA inspector had interest to see what were ZPMC findings after the removal of the ceramic backing. Mr. Shen Xu Jun agreed. The QA inspector informed Task Leaders Davis McClary and Robert Cuellar about ZPMC repairing linear indications identified as lack of fusion and performing MT without notifying Caltrans.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Acuna,Alfredo

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer